

Work Order ID 60033

June 23, 2010 8:36:50 AM



Page 1

Item ID: D2197-2

Accept



Setup

Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 6/23/10

Start Qty: 1.00



Cust Item ID:

Required Date: 6/25/10

Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 10/6/23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2197

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2196 ☒ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

304 .063

B10-6-23



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B10-6-23

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/6/23



W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60033

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Page 2

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Customer:

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Run

Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

Bend as per dwg D2196

SS 10/06/21

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

SS 10/06/24

(41)

-2

150



Packaging

Identify as per dwg & Stock Location: PON

0.00

Memo

0.00

Packaging

10/16/20 (1)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Revision ID:

Item Name: Bracket

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Start Date: 6/23/10

Start Qty: 1.00



Cust Item ID:

Required Date: 6/25/10

Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run

Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/28

C21016125

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 23, 2010 8:36:49 AM

Page 1

Work Order ID: 60033

Parent Item: D2197-2

Parent Item Name: Bracket

Start Date: 6/23/10

Start Qty: 1.00

Required Date: 6/25/10

Required Qty: 1.00

Comments: IPP Rev:A 08-07-24 new issue ec verified by:dd

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	77.7900	0.1388	0.146105			



304/316 Sheet .063



1810-6-23

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	77.79	
111323	0	
114799	77.79	

114799

①

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	60033
Description: Bracket		Part Number:	D2197-2
Inspection Dwg: D2197	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.134	✓			
Ø0.203	+0.005/-0.001	.207	✓			
Ø0.257	+0.006/-0.001	.261	✓			
0.300	+/-0.010	.302	✓			
0.375	+/-0.010	.374	✓			
0.500	+/-0.010	.502	✓			
1.200	+/-0.010	1.197	✓			
2.390	+/-0.010	2.385	✓			
3.280	+/-0.010	3.271	✓			
4.480	+/-0.010	4.481	✓			
4.980	+/-0.010	4.977	✓			
0.500	+/-0.010	.500	✓			
0.813	+/-0.010	.815	✓			
1.750	+/-0.010	1.752	✓			
2.688	+/-0.010	2.682	✓			
3.625	+/-0.010	3.631	✓			
4.000	+/-0.010	4.002	✓			
0.063	+/-0.010	.060				

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 10-6-23	Date: 10/06/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.08.27	New Issue	KJ/DD	

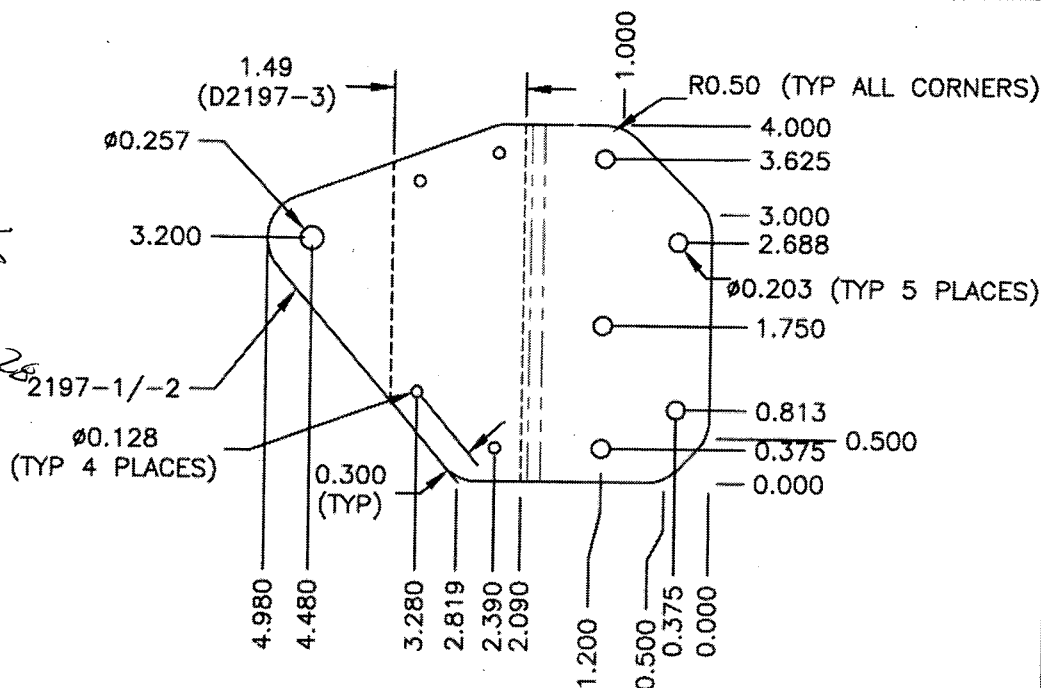


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2197	REV. C SHEET 1 OF 1
DATE 03.05.28		TITLE BRACKET	SCALE 1:2
B	93.09.23	REDESIGN	
C	03.05.28	REDRAW; D2197-3 NOW 0.5" THICK	

RELEASED
03.07.04

UNDER REVIEW

D2197-1/-2/-3
FLAT PATTERN



D2197-1/-2

- 1) MATERIAL: AISI 304/316 S.S.
0.064" THICK (M304S16GA)

D2197-3

- 2) MATERIAL: 5052H32 (QQ-A-250/8)
0.500" THICK OR 4x0.125 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1

D2197 BRACKET (ASSEMBLY):

- 4) FINISH: POWDER COAT WHITE (4.3.5.1)
PER DART QSI 005 4.3

GENERAL NOTES:

- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.015

D2197 BRACKET
(ASSEMBLY)

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